

# Work Order ID 81005

\*81005\*

Page 1

Item ID: D4091-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Mounting Lug

Stop

\*NS2\*

Start Date: 3/6/2012 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 3/14/2012 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan: *mk*

Date: 12-03-06

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4091

A

100

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

*cut @ meter*

110

0.00

\*110\*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

DEBURR

*issue R/O to meter 16357*

*machine as per dwg D4091 REV.A*

*CD 12/03/06 24*

**Work Order ID 81005****\*81005\***

Page 2

Item ID: D4091-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Mounting Lug

Start Date: 3/6/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 3/14/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp120 *rec'd*  
**\*120\***

QC

Quality Control

~~QC2 Inspect parts off machine F A I / F A I B~~

0.00

Memo

0.00

*rec'd & inspect for transit damage.  
attachd c/c to w/o*

130

**\*130\***

QC

Quality Control

~~QC3~~ Inspect parts - second check

0.00

Memo

0.00

*S. 12/03/13**counts  
(24)*

140

**\*140\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*24X Ø M- 12/03/13*

• Work Order ID 81005

\*81005\*

Page 3

Item ID: D4091-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Mounting Lug

Start Date: 3/6/2012 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 3/14/2012 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*150\*

Powdercoat

Powder Coating

Memo

start - 3h35  
Temp - 320°F  
Finish - 4h05

0.00

M120222

24

24 BR (2P)

12/03/13

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Quality Control

Memo

0.00

24 12/03/13

170

Identify as per dwg & Stock Location: 458

0.00

\*170\*

Packaging

Packaging

Memo

0.00

12/3/14 (24)

Work Order ID 81005

\*81005\*

Item ID: D4091-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Mounting Lug

Start Date: 3/6/2012 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 3/14/2012 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

12/3/14

112-03-14

# Picklist Print

Tuesday, March 06, 2012 12:54:24 PM

Page 1

Work Order ID: 81005  
Parent Item: D4091-1  
Parent Item Name: Mounting Lug

Start Date: 3/6/2012 Required Date: 3/14/2012  
Start Qty: 24.00 Required Qty: 24.00

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	339.2200	0.1251	3.1604211			

Location

MAT006

43722

45800

68331

Loc Qty

339.22

161.5

1

176.72

Loc Code

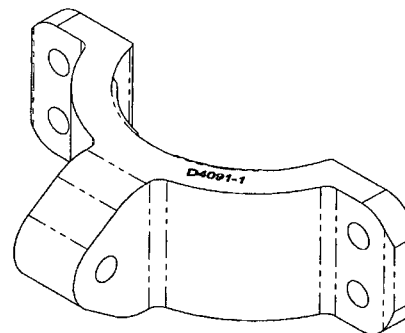
CL12/03/06

3.16

D 4091-1 P

x 24

6/23/12 (24)



**D4091-1 MOUNTING LUG**

# 81005

**RELEASED**  
2010-04-28  
MD

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION WITH A TOOL TIP RADIUS OF  $0.015 \pm 0.005$
- 7) WEIGHT: 0.31 lbs

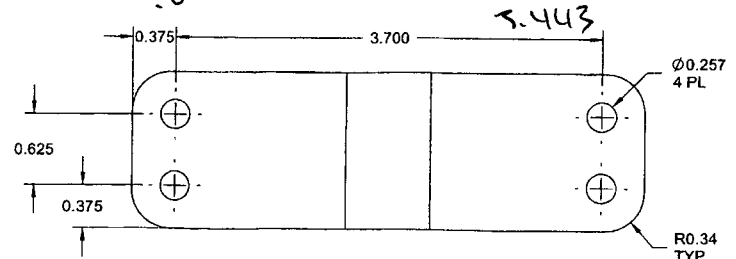
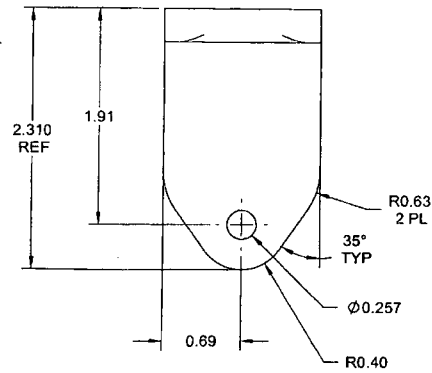
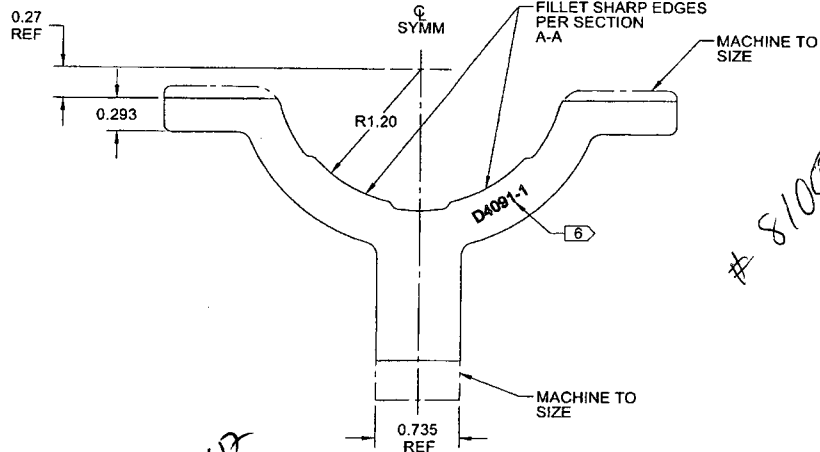
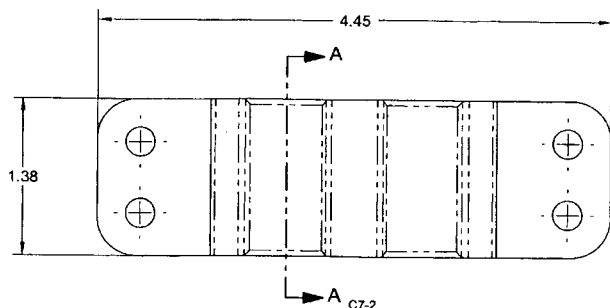
A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	CP			SHEET 1 OF 2	
CHECKED		DRAWING NO. D4091		SCALE	
MFG. APPR.		TITLE		NTS	
APPROVED		MOUNTING LUG			
DE APPR.					
DATE	10.03.29				

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
R0.03-R0.07  
TYP AROUND PAD

**SECTION A-A** C5-2



**D4091-1 MOUNTING LUG**

**RELEASED**  
2010-04-20  
AM

DESIGN			<b>DART AEROSPACE LTD</b>	
DRAWN	GP		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			<b>D4091</b>	SHEET 2 OF 2
APPROVED			TITLE	SCALE
DE APPR.			<b>MOUNTING LUG</b>	NTS
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 81005
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D4091-1
<b>Inspection Dwg:</b> D4091	<b>Rev:</b> a	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/-0.030	1.381	✓		vern	ED-0026
4.45	+/-0.030	4.449	✓			
0.27 REF	+/-0.030	.27	✓			
1.91	+/-0.030	1.910	✓			
0.69	+/-0.030	0.692	✓			
0.293	+/-0.010	0.293	✓			
0.735 REF	+/-0.010	0.733	✓			
0.375	+/-0.010	0.375	✓			
3.700	+/-0.010	3.697	✓			
0.625	+/-0.010	0.622	✓			
0.375	+/-0.010	0.375	✓			
Ø0.257	+0.006/-0.001	0.257	✓			
R0.40	+/-0.030	0.40	✓		R-g	
2.310 REF	+/-0.010	2.311	✓		thick gauge	

<b>Measured by:</b> N/A	<b>Audited by:</b> S	<b>Preliminary Approval:</b>
<b>Date:</b>	<b>Date:</b> 12/13/13	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.08.05	New Issue	KJ	AA



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 18514  
**Date:** Mar 12, 2012  
**Page:** 1

<b>Sold to:</b> <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
<b>Order No.:</b> PO16357		<b>Sold By:</b> Dewar, Eric	
<b>Shipped By:</b> our truck		<b>Ship Date:</b> Mar 12, 2012	

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D4091-1 Lug as per drawing D4091 Rev.A B81005	Each	24	24	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.		Thank you for your order!		
Received by _____				



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
24	D4091-1	Lug	18514

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, March 12, 2012